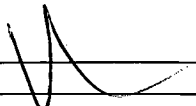


Date: Friday, 30/05/2008 10:48:39 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT FACING SEAT ASS'Y RH	
<b>Job Number</b> : 39610		
<b>Estimate Number</b> : 13314		
<b>P.O. Number</b> :	<b>Part Number</b> : D412769042	<b>FOR ENGINEERING USE ONLY</b> 01.06.06
<b>This Issue</b> : 30/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D412-769-042 PROTO	
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A	
<b>First Issue</b> : 30/05/2008 <b>Type</b> : R & D SM/MED FAB	<b>Drawing Revision</b> : PROTO	
<b>Previous Run</b> :	<b>Material</b> :	
<b>Written By</b> : 	<b>Due Date</b> : 06/06/2008	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :		
<b>Comment</b> : Est rev A 08.05-12 new issue DD verified by:ec		

Additional Product

PROTOTYPE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
-----	----------	-------------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Back Leg Assembly  
 batch: 305011

080530

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Front Inboard Leg Assembly  
 batch: 305014

080530

4.0	D3782044	Front Outboard Leg Assembly, RH
-----	----------	---------------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Front Outboard Leg Assembly, RH  
 batch: 305012

080530

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Lateral Brace Assembly  
 batch: 305005

080530

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B05006

A

080530

7.0

D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B05007

A

080530

8.0

D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B05010

A

080530

9.0

D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B05009

A

080530

10.0

D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B05008

A

080530

11.0

D37662

Front Rail, RH



D37712



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B39531

A

080530

12.0

D37663

Rear Rail



D37713



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B39532

A

080530

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37671

Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch:

338866

PA

080530

14.0

D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch:

REF BELL S/N 30856

USE

BHT PN 205-070-725-011

080603

15.0

AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch:

M107938

PA

080530

16.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch:

M107321

PA

080530

17.0

NAS1149F0563P

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Washer

batch:

M108099

PA

080530

18.0

NAS1149F0463P

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M5519

PA

080530

19.0

AN515A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

batch:

M108077

PA

080530

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN510A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107013

080530

21.0

AN513A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107321

080530

22.0

MS21042L5

Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Nut

batch: M107464

080530

23.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 106051

080530

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-042

080530

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08.05.30

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-mask D3787-1 foot and around area of red powder coat as per dwg D412-769-042

2-Powder coat only D3782-041 and D3782-043 front legs in red as per dwg D412-769-042

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

N/A 08.06.07

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

28.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-042

2- Powder coat remainig of assembly grey as per dwg D412-769-042

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

N/A  
For  
test  
PLH  
06.05.09

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37742 03774-1

Seat Bottom, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, RH

batch: B39703

*[Signature]*

06.06.06

32.0

D37744 03774-3

Seat Back, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, RH

batch: ~~B39703~~ B39704

*[Signature]*

06.06.06

~~080604~~

B39704

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN52510R24

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: ~~M105953~~

~~AN52510R24~~ AN52510R22

~~080603~~ 080603

34.0

NAS1149F0363P

Washer



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Washer

batch: ~~N5519~~

AN 960-10

~~080603~~ 080603

35.0

MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: ~~M107644~~

~~080603~~ 080603

36.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: ~~M100188~~

~~080603~~ 080603

37.0

D412724041

Head Rest Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch: ~~B38956~~ B38956

~~080604~~ 080604

38.0

D412724044

Head Rest Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, RH

Batch: ~~B38958~~ B38958

~~080604~~ 080604

39.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-042

~~080604~~ 080604

Date: Friday, 30/05/2008 10:48:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 39610

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC5

INSPECT WORK TO CURRENT STEP



PTO  
08.08.08

Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING**  
**APPROVAL**

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A.

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.06. Prototype

Job Completion



change to W/O # 00186 L 08/06/11

ANS25 10R22 (M107936) screws used at locations  
that interfere with installation of D3774-1 Seat Bottom  
and D3774-3 Seat back.

605t-76 Tubing installed at these locations to  
compensate for  $\phi 5/16$  hole to  $\phi 3/16$  hole.

MSA1042 nut (M107644)

17N9605D106 washer (M104885)

~~Ref~~

08-08-05

Accounted

on

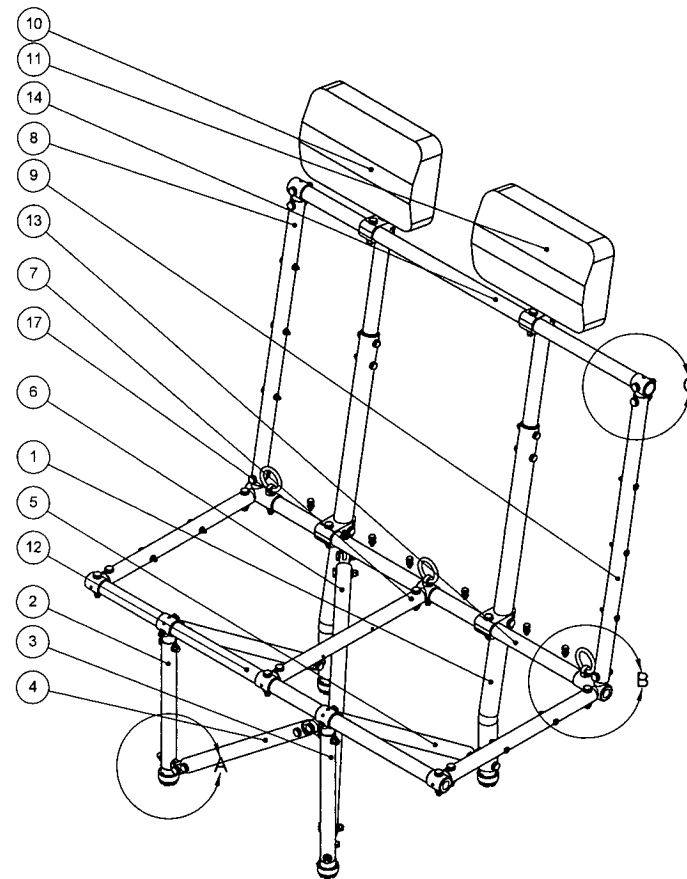
mat'l

req

form



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D412-724-041	HEAD REST ASSY, CENTER	1
11	D412-724-044	HEAD REST ASSY, RH	1
12	D3766-2	FRONT RAIL, RH	1
13	D3766-3	REAR RAIL	1
14	D3767-1	UPPER RAIL	1
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	D3792-1	SEAT BELT EYE BOLT	3
18	AN45-13A	EYE BOLT	1
19	AN5-10A	BOLT	6
20	AN5-13A	BOLT	2
21	AN5-15A	BOLT	9
22	AN4-15A	BOLT	2
23	AN3-5A	BOLT	6
24	AN525-10R24	SCREW	10
25	MS21042L3	NUT	16
26	MS21042L4	NUT	2
27	MS21042L5	NUT	21
28	NAS1149D0363J	WASHER (AN960JD10)	22
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	38



**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

08.06.06 PB

8

**D412-769-042 AFT FACING SEAT, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3) AND HEAD RESTS (D412-724-041, -044). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO THE BACK OF SEAT BACK
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.04		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. <b>D412-769-2</b>		SHEET 1 OF 3
TITLE <b>AFT FACING SEAT ASSY, RH</b>		SCALE NTS
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8

7

6

5

4

3

2

1

D

C

B

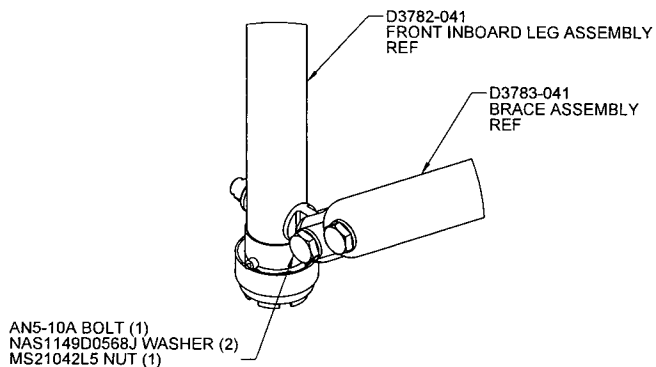
A

D

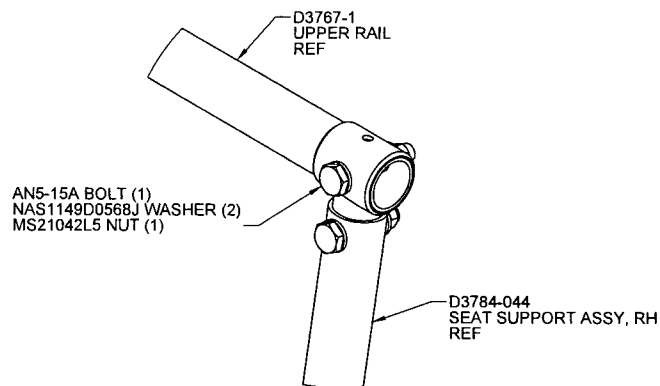
C

B

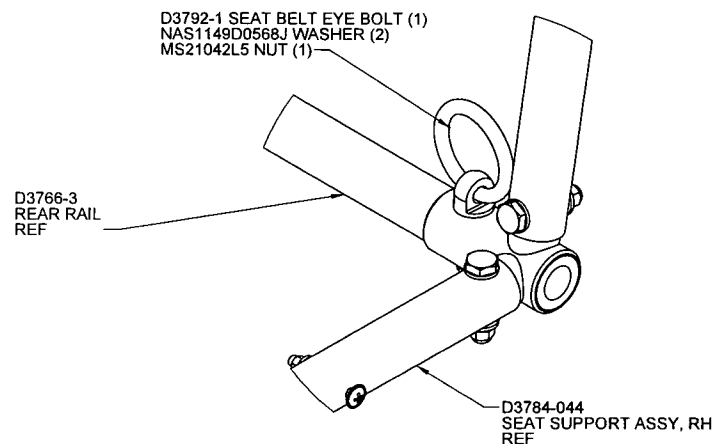
A



**DETAIL A**  
**BRACE ATTACHMENT (TYP)**



**DETAIL C**  
**SEAT SUPPORT END ATTACHMENT (TYP)**



**DETAIL B**  
**SEAT SUPPORT ATTACHMENT (TYP)**

**PROTOTYPE**  
**PLEASE RETURN ALL ISSUED**  
**DATA TO ENGINEERING**  
06.06.06 *RLB*

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
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MFG. APPR.		D412-769-2	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
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8

7

6

5

4

3

2

1

8

7

6

5

4

3

2

1

AN525-10R24 SCREW (1)  
NAS1149D0363J WASHER (1)  
MS21042L3 NUT (1)  
TYPICAL  
3 PLACES PER SIDE

D3784-044  
SEAT SUPPORT, RH  
REF

D3774-3  
SEAT BACK  
REF

### SECTION D-D

AN525-10R24 SCREW (1)  
NAS1149D0363J WASHER (1)  
MS21042L3 NUT (1)  
TYPICAL  
2 PLACES PER SIDE

D3774-1  
SEAT BOTTOM  
REF

D3784-044  
SEAT SUPPORT, RH  
REF

### SECTION F-F

D3774-3  
SEAT BACK  
REF

D3774-1  
SEAT BOTTOM  
REF

D3766-2  
FRONT RAIL  
REF

D3766-3  
REAR RAIL  
REF

AN3-5A BOLT (1)  
NAS1149D0363J WASHER (2)  
MS21042L3 NUT (1)  
TYPICAL  
6 PLACES

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED DATA TO ENGINEERING  
01.06.06

### SECTION E-E

#### NOTES:

- 1) TRANSFER DRILL HOLES  $\varnothing 0.201$  FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PLACES/SIDE
- 2) TRANSFER DRILL HOLES  $\varnothing 0.201$  FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PLACES/SIDE
- 3) TRANSFER DRILL HOLES  $\varnothing 0.201$  FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PLACES

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-2	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

4

3

2

1

**Material Requisitions**

CL

Part Number: AN52510R22

Batch Number: M107936

R/S#: \_\_\_\_\_

Quantity: 20

Required by: AD Date: 080604

**Used for**

Part Number: 00196

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_

TA TRANSIQAIMATERIAL REQ-A.DOC

**Material Requisitions**

CL

Part Number: AN525-10R22

Batch Number: M107936

R/S#: \_\_\_\_\_

Quantity: 18

Required by: AD Date: 080603

**Used for**

Part Number: 00196

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_  
\_\_\_\_\_

TA TRANSIQAIMATERIAL REQ-A.DOC

### Material Requisitions

Part Number: MS21042L3

Batch Number: M107644

R/S#: \_\_\_\_\_

Quantity: 20

Required by: JA Date: 080604

#### **Used for**

Part Number: 00196

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_

T:\TRANSIQ\A\MATERIAL REQ-A.DOC

### Material Requisitions

Part Number: MS21042L3

Batch Number: M107644

R/S#: \_\_\_\_\_

Quantity: 18

Required by: JA Date: 080603

#### **Used for**

Part Number: 00196

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_

T:\TRANSIQ\A\MATERIAL REQ-A.DOC

### Material Requisitions

Part Number: AN9605D10L

Batch Number: M104885

R/S#: \_\_\_\_\_

Quantity: 40

Required by: JA Date: 080604

#### **Used for**

Part Number: 00196

Batch Number: \_\_\_\_\_

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments: \_\_\_\_\_

T:\TRANSIQ\A\MATERIAL REQ-A.DOC